

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021264**Date Inspected:** 03-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

| | | | |
|------------------------------------|--------------|----|-----|
| CWI Name: | Anqing Xiang | | |
| Inspected CWI report: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A |

| | | |
|----------------------------------|-----|--------|
| CWI Present: | Yes | No |
| Rod Oven in Use: | Yes | No N/A |
| Weld Procedures Followed: | Yes | No N/A |
| Verified Joint Fit-up: | Yes | No N/A |
| Approved WPS: | Yes | No N/A |
| Delayed / Cancelled: | Yes | No N/A |

Bridge No: 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

OBG Segment 9AW-9BW

Shielded Metal Arc Welding (SMAW) in the 4G position of Bottom Panel repaired area as per repair report # B-WR-13906, weld joint OBW9B-003. The welder is identified as 067609. ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-Repair-1. See attached photograph Pic_001

OBG Segment 9AW-9BW

Shielded Metal Arc Welding (SMAW) in the 4G position of Side Panel repaired area at Counterweight side as per repair report # B-WR-13907, weld joint 9BW9B-002. The welder is identified as 068097. ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)Repair-1.

OBG Segment 9AW-9BW

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During in process visual inspection of 9AW, This QA Inspector observed ZPMC NDT personnel Mr. Rudy performing Ultrasonic Testing (UT) on Cross Beam side Corner Assembly Deck Panel.

OBG Segment 9BE-9CE

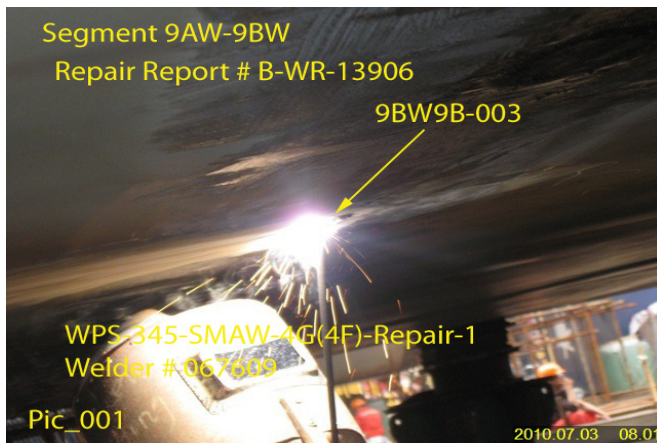
During in process visual inspection of 9BE-9CE, This QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) on Side Panel of Bike Path side. See attached photograph Pic_002

OBG Segment 9AW

Flux Core Arc Welding (FCAW) in the 1G position of Counterweight side LD to Floor Beam, weld joint SEG049B. The welder is identified as 045143. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with B-T-2231-TC-U4B-F.

OBG Segment 9AW-9BW

During in process visual inspection of 9AW, This QA Inspector observed ZPMC NDT personnel Mr. Xu Wei performing Ultrasonic Testing (UT) on Counterweight side Edge Panel.



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By: Gade,Ramesh

Quality Assurance Inspector

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Reviewed By: McClendon, Timothy

QA Reviewer